

Work Order ID 83273 -2

April-16-12 1:38:05 PM

83273

Page 1

Item ID: D2230-1

Revision ID:

Item Name: Lug

Start Date: 16/04/2012 Start Qty: 160.00

Required Date: 30/04/2012 Req'd Qty: 160.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MJS

QC:

Date: 12/04/16 Tooling:

Date: SPC (Y/N):

Date:

Run Start *NR1*

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut D2423 extrusion to 0.82"

Batch:

cut @ metec

110

110

HAAS 1 Punch

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine per folio FA927

DWG REV:

FOLIO REV:

(Check for crack while loading into the machine.)

2- deburr rough edges

P/O: 10747

issue P/O to metec.

Machine as per drawing D2230 REV. G

CL 12/04/18

CL 12/04/18 160

Work Order ID 83273

83273

Page 2

Item ID: D2230-1

Accept

Revision ID:

N9000040100

Setup Start *NS1*

Item Name: Lug

Stop *NS2*

Start Date: 16/04/2012 Start Qty: 160.00

160

Required Date: 30/04/2012 Req'd Qty: 160.00

160

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130 *need*
130
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*need + inspect for tensile damage
attached cafe to 1010*

QC3- Inspect parts - second check

0.00

Memo

0.00

130
130
QC
Quality Control

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

140
140
HandFinish
Hand Finishing

*Box
10/2/10/22 (110)*

*SP
12-5-11
W/W 12.05.23*

(110)

110 216 12.5.24

Work Order ID 83273

April-16-12 1:38:05 PM

83273

Page 3

Item ID: D2230-1

Accept

N19000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 16/04/2012 Start Qty: 160.00

160

Required Date: 30/04/2012 Req'd Qty: 160.00

160

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

QC3- Inspect Part Finish

0.00

150

QC

Quality Control

Memo

0.00

110x

m.f
12/05/11

160

160

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:40
320 °F
11:10

0.00

110x

m.f
12/05/11

170

170

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

110

12/05/11

m121134

Work Order ID 83273

April-16-12 1:38:06 PM

83273

Page 4

Item ID: D2230-1

Accept

Revision ID:

N900040100

Setup Start *NS1*

Item Name: Lug

Stop *NS2*

Start Date: 16/04/2012 Start Qty: 160.00

160

Required Date: 30/04/2012 Req'd Qty: 160.00

160

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Number Insp.
Stamp

180

Identify as per dwg & Stock Location: ST480 0.00

180

Packaging

Memo

0.00

Packaging

110

545 12/06/04

190

QC21- Final Inspection - Work Order Release 0.00

190

QC

Memo

0.00

Quality Control

12/6/4

MF

12-06-03

Picklist Print

April-16-12 1:38:10 PM

Page 1

Work Order ID: 83273

83273

Parent Item: D2230-1

D2230-1

Parent Item Name: Lug

Start Date: 16/04/2012

Required Date: 30/04/2012

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P		Purchased	No				Each	0.0000		160		6/4/12 (110)	
D2230-1P									**				
LUG													
D2423		Manufactured	No			110	f	273.1180	0.0683	11.50316		SP 12-5-11	
D2423									**				
Lug Extrusion												CH 12104113	

Location

MAT006

Loc Qty

273.118

Loc Code

43722

161.5

45800

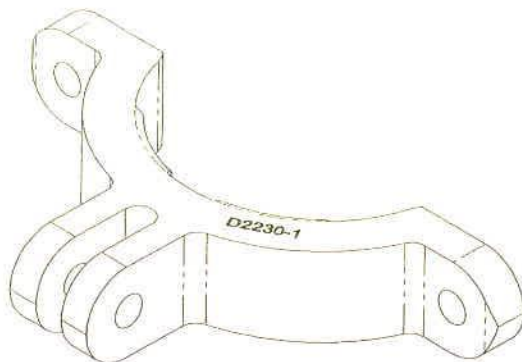
1

68331

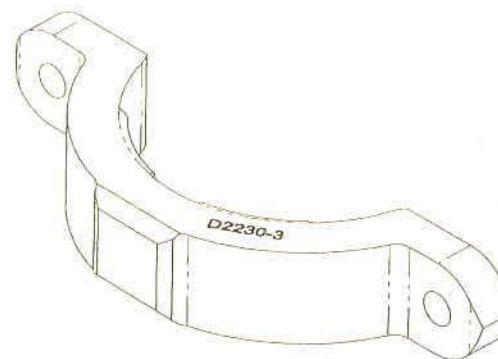
110.618

81557

11.50



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83273 MCT
12/04/16

RELEASED
9/6/15 MCT

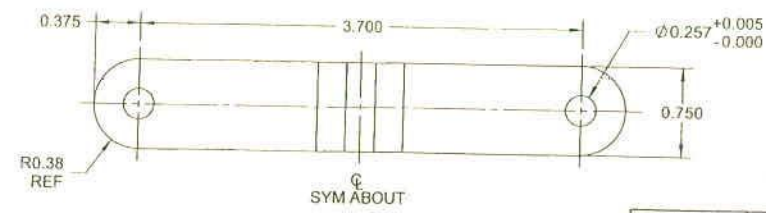
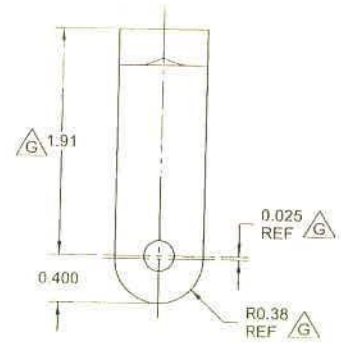
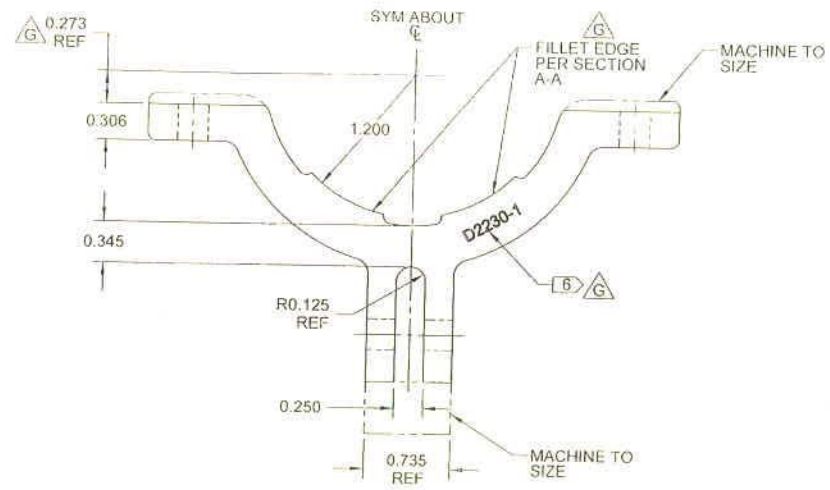
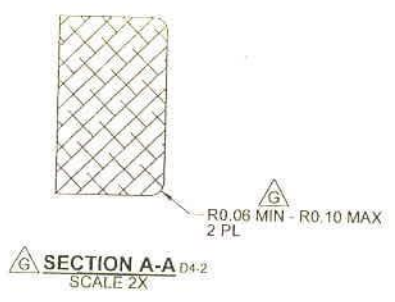
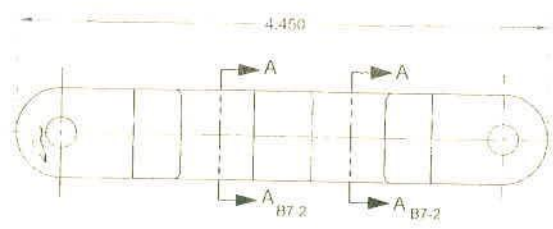


NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS
OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. D2230	REV. G
MFG. APPR.	<i>[Signature]</i>	SHEET 1 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNTING LUG	NTS
DATE	09.01.16	<small> COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

83273

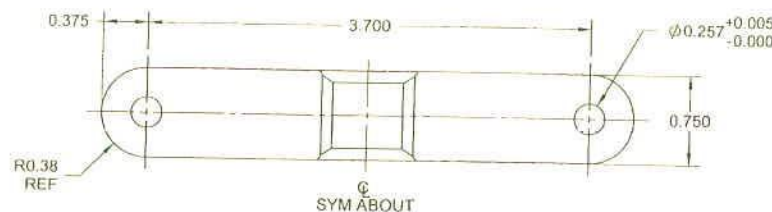
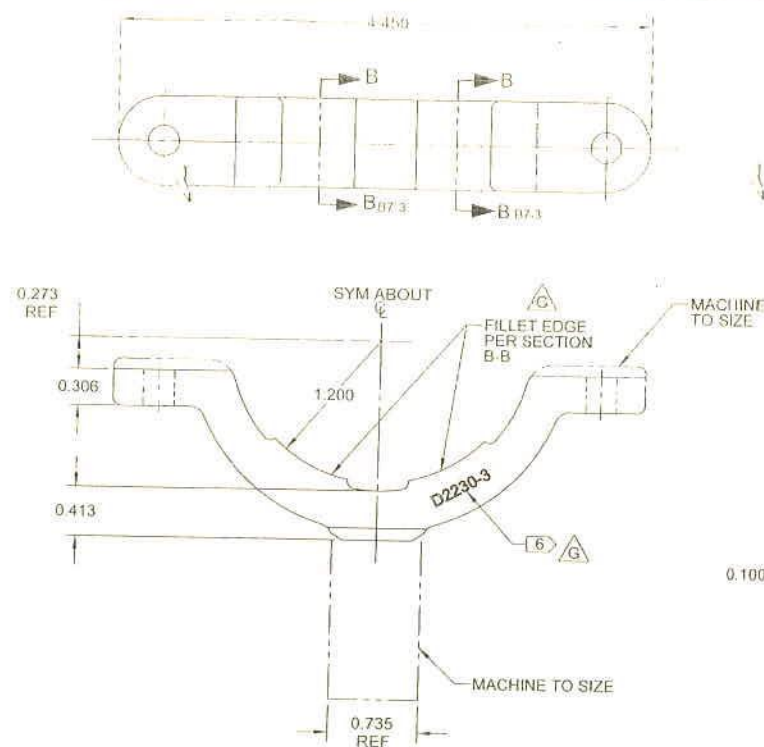
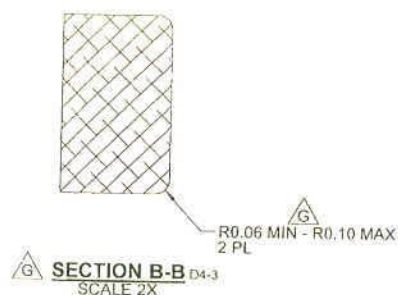


D2230-1 MOUNTING LUG

RELEASED
09/06/25/16

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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83273



D2230-3 MOUNTING LUG

RELEASED
09/06/25M

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO16747**

Purchase Order Date **4/18/12**

PO Print Date **4/18/12**

Page Number **1 of 1**

Order From:

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Laviole

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Amount
1	D2230-1P	LUG	5/04/12 Yes	160.00 Each	Dart Truck	\$18.4300	\$2,948.80
Special Inst:			AS PER DWG D2230 REV. G B83273				
2	D2230-3P	LUG	5/04/12 Yes	160.00 Each	Dart Truck	\$18.4300	\$2,948.80
Special Inst:			AS PER DWG D2230 REV. G B83261				
3	D3235-1P	lug	5/04/12 Yes	100.00 Each	Dart Truck	\$15.5000	\$1,550.00
Special Inst:			AS PER DWG D3235 REV. A B83311				

PO Total:

\$6,447.60

No substitution or declaration in this
consent.

Certificate of Conformance
Certification required when applicable.

Change Nbr:

Change Date: 4/18/12



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18688
Date: May 16, 2012
Page: 1

Sold to:	Ship to:
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 16747	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug	Each	160	110	
D2230-3 Mounting Lug	Each	160		
D3235-1 Mounting Lug	Each	100		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
110	D2230-1	Lug	16747

MATERIAL: supplied by DART B81577

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi Walz

Vankleek Hill, May 16, 2012